

Work Order ID 131573

Thursday, April 16, 2015 8:00:37 AM

131573

Page 1

Item ID: D350-578-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw Installation

Start Date: 4/16/2015 Start Qty: 7.00

7

Cust Item ID:

Required Date: 4/16/2015 Req'd Qty: 7.00

7

Customer:

Reference:

Approvals: Process Plan: *MCD*

Date: *504-16*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-578	H								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-578-011 CHG006								
160	Pick Kit	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC4- 100% Inspect kits for completeness	0.00							
170									
QC	Memo	0.00							
Quality Control									

(74)

DAS
46
9-89

APR 20 2015

7x

DAS
20
9-89

APR 16 2015

(7x)

DAS
46
9-89

APR 20 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

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Page 2

Item ID: D350-578-011

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Item Name: Bearpaw Installation

Start Date: 4/16/2015 Start Qty: 7.00

7

Cust Item ID:

Required Date: 4/16/2015 Req'd Qty: 7.00

7

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Qty Number Stamp

180

0.00

180

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-578-
011 Location: FG-013DAS
46
9-89

APR 20 2015

190

0.00

190

QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

15/4/22

15.4-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Thursday, April 16, 2015 8:00:45 AM

Page 1

Work Order ID: 131573

131573

Parent Item: D350-578-011

D350-578-011

Parent Item Name: Bearpaw Installation

Start Date: 4/16/2015

Required Date: 4/16/2015

Start Qty: 7.00

Required Qty: 7.00

Comments:

IPP Rev:A New Issue 07-01-02 JLM
IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2432
D2432
Bearpaw 19" X 24"

DAS
46
9-89

Manufactured

No

160

Each

1.0000

2

14

**

14X B131001

DAS
26
9-89

Location

Loc Qty

Loc Code

PKG

1

127600

1

D2529

D2529
Washer

DAS
46
9-89

Manufactured

No

160

Each

350.0000

12

84

**

Location

Loc Qty

Loc Code

ST008

350

128950

350

D3601-1

D3601-1
Radius Block

DAS
46
9-89

Manufactured

No

Each

95.0000

**

12X 84

Location

Loc Qty

Loc Code

ST051

77

131259

77

ST051A

18

124090

18

APR 16 2015

DAS
26
9-89

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

Picklist Print

Thursday, April 16, 2015 8:00:45 AM

Page 2

Work Order ID: 131573

Parent Item: D350-578-011

Parent Item Name: Bearpaw Installation

131573

D350-578-011

Start Date: 4/16/2015

Required Date: 4/16/2015

Start Qty: 7.00

Required Qty: 6.00

D4011-1
D4011-1
Clamp, Short
DAS
46
9-89

Manufactured No

Each 106.0000
** 6x 42

Location	Loc Qty	Loc Code
ST542	106	
130923	106	

D4012-1
D4012-1
Cushion
DAS
46
9-89

Manufactured No

Each 106.0000
** 6x 42

Location	Loc Qty	Loc Code
ST545	106	
131213	106	

AN4-16A
AN4-16A
Bolt
DAS
46
9-89

Purchased No

Each 214.0000
** 12x 84

Location	Loc Qty	Loc Code
FG	5	
121541	5	
ST325A	5	
M131800	5	
ST343	204	
M128813	4	
M132035	200	

5x
79x

APR 16 2015

Thursday, April 16, 2015 8:00:45 AM

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Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								

Picklist Print

Thursday, April 16, 2015 8:00:45 AM

Page 3

Work Order ID: 131573

Parent Item: D350-578-011

Parent Item Name: Bearpaw Installation

131573

D350-578-011

Start Date: 4/16/2015

Required Date: 4/16/2015

Start Qty: 7.00

Required Qty: 7.00

DAS
26
9-89

NAS1149D0463J

Purchased

No

160

Each

5,679.000

24

168

NAS1149D0463J
WASHER

DAS
46
9-89

**

m13203543x

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST269

5638

M129682

211

M130799

427

M132035

5000

125

MS21042L4

Purchased

No

160

Each

1,529.000

12

84

MS21042L4
Locknut

DAS
46
9-89

**



DAS
26
9-89

APR 16 2015

Location

Loc Qty

Loc Code

FP001

42

m124231

42

GA

574

m127813

574

ST260a

370

m130799

56

m131803

314

ST305

543

426

426

m128300

8

m130922

97

m131618

12

84x

Thursday, April 16, 2015 8:00:46 AM

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Page 3

REFERENCE ONLY

DART AEROSPACE LTD.

APR 20 2015

DAS
46
9-89

D350-578
Page 13 of 13

5.0 PARTS LIST

5.1 D350-578-011/-013/-015/-017/-021 BEARPAW INSTALLATION

Qty -011	Qty -013	Qty -015	Qty -017	Qty -021	Qty -031	Part Number	Description
X						D350-578-011	BEARPAW INSTALLATION
	X					D350-578-013	BEARPAW INSTALLATION
		X				D350-578-015	BEARPAW INSTALLATION
			X			D350-578-017	BEARPAW INSTALLATION
				X		D350-578-021	BEARPAW INSTALLATION
					X	D350-578-031	WEARPLATE KIT
2						D2432F	Bearpaw
		2				D2432-3	Bearpaw
12	12	12	12	12		D2529	Washer
				2		D2672F	Bearpaw
12	12	12	12	12		D3601-1	Radius Block (Replaces D2274)
					2	D3859-041	Wearplate
6	6	6	6	6		D4011-1	Clamp (Replaces D2438)
6	6	6	6	6		D4012-1	Cushion (Replaces D2182B050)
	2					D4297-1	Bearpaw
			2			D4297-3	Bearpaw
12	12			12	12	AN4-16A	Bolt
		12	12		12	AN4-17A	Bolt
24	24	24	24	24	24	NAS1149D0463J	Washer
12	12	12	12	12	12	MS21042L4	Nut (or MS21042-4)

5.2 D350-578-111/-113/-115/-117/-121 BEARPAW INSTALLATION

Qty -111	Qty -113	Qty -115	Qty -117	Qty -121	Part Number	Description
X					D350-578-111	BEARPAW INSTALLATION
	X				D350-578-113	BEARPAW INSTALLATION
		X			D350-578-115	BEARPAW INSTALLATION
			X		D350-578-117	BEARPAW INSTALLATION
				X	D350-578-121	BEARPAW INSTALLATION
1					D350-578-011	Bearpaw Installation
	1				D350-578-013	Bearpaw Installation
		1			D350-578-015	Bearpaw Installation
			1		D350-578-017	Bearpaw Installation
				1	D350-578-021	Bearpaw Installation
1	1	1	1	1	D350-578-031	Wearplate Kit

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Revision: H

Date: 15.03.12